

Date: Thursday, 20/11/2008 3:35:29 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SHAFT SLEEVE		
Job Number	: 43627		Part Number	: D32337		
Estimate Number	: 11155		Drawing Number	: D3233 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 20/11/2008	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : MACHINED PARTS	Due Date	: 21/12/2008	Qty:	10 Um: Each
Previous Run	: 37648					
Written By	:					
Checked & Approved By	: JLD 08.11.21					
Comment	: Est. A 05.03.14 New issue KJJLM Est Rev:B Now on Doosan Lathe 08-04-01 JLM Verified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1020TR1375W125	ROUND TUBE 1.375 x .125w

Comment: Qty.: 0.1860 f(s)/Unit Total : 1.8596 f(s)
1020-1025 Round Tube
Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020
SRA or AMS 5075 or AMS 5077
(M1020TR1.375W.125)
Identify for D3233-7
Batch: 5101934

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: Doosan Lathe

1- Turn as per Folio FA735 Rev: W/A & Dwg D3233 Rev: B

2.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 08/12/23

Dart Aerospace Ltd.
www.dart-aerospace.com

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:35:29 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHAFT SLEEVE

Job Number: 43627

Part Number: D32337

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		<i>Pu 8/12/24 (1) ST 483 BANCAT</i>
6.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		<i>u 08.12.24</i>

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43627
Description: Shaft Sleeve	Part Number:	D3233-7
Inspection Dwg: D3233 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

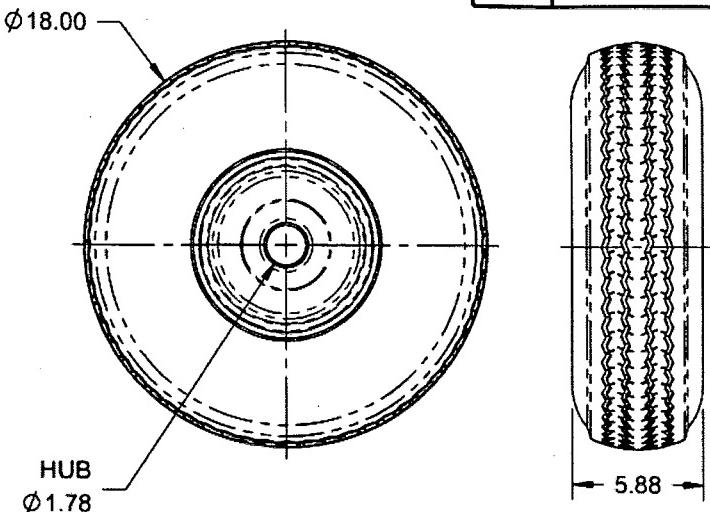
X First Article Prototype

Measured by:	<u>Raf</u>	Audited by:	<u>JL</u>	Prototype Approval:	N/A
Date:	08/12/23	Date:	08/12/23	Date:	N/A

Rev	Date	Change	Revised by,	Approved
A	07.10.30	New Issue	KJ/EC/DD	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	D3233	REV. B SHEET 1 OF 3
DATE	05.03.08	TITLE	WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE		
B	05.03.08	ADDED BEARING SEALS		

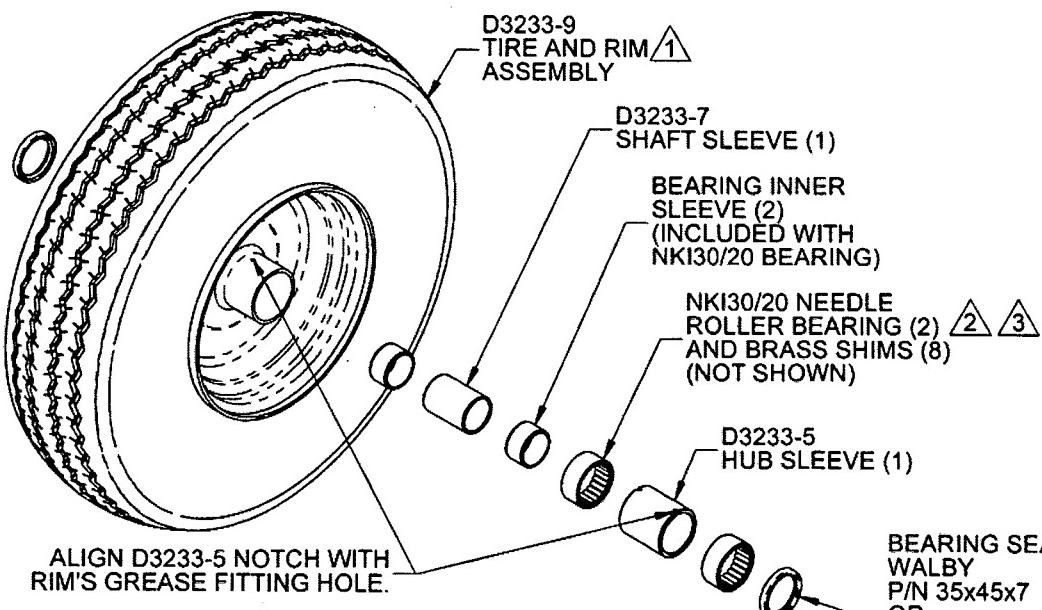


RELEASED
[Signature]
05/05/04

WHEEL SPECIFICATIONS

SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMMENDATIONS
ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

NOTES:

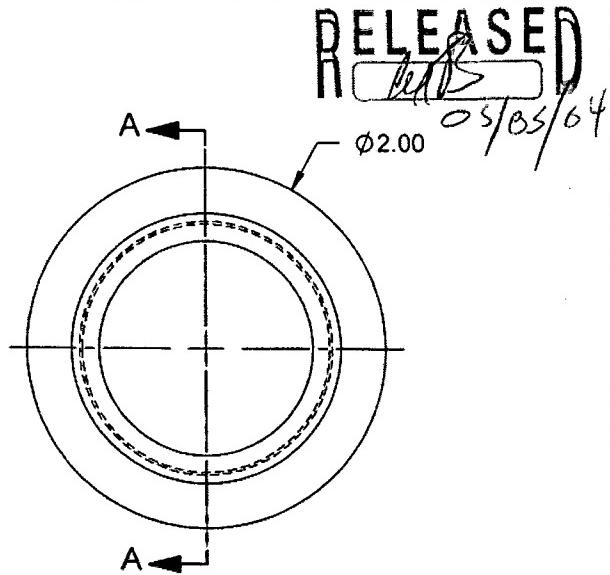
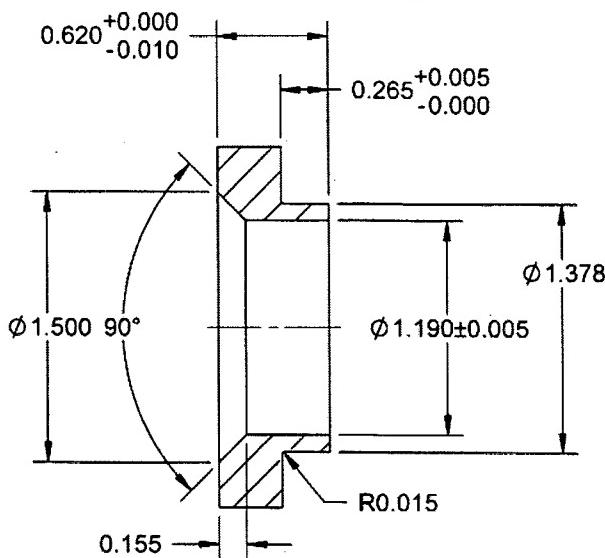
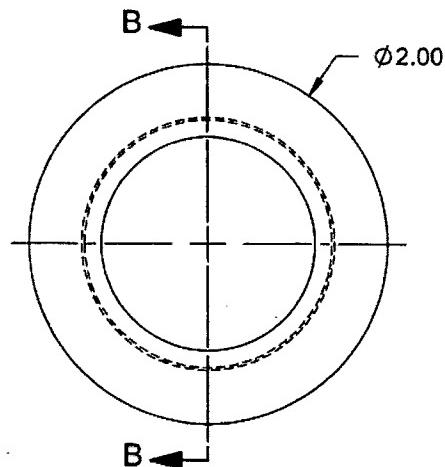
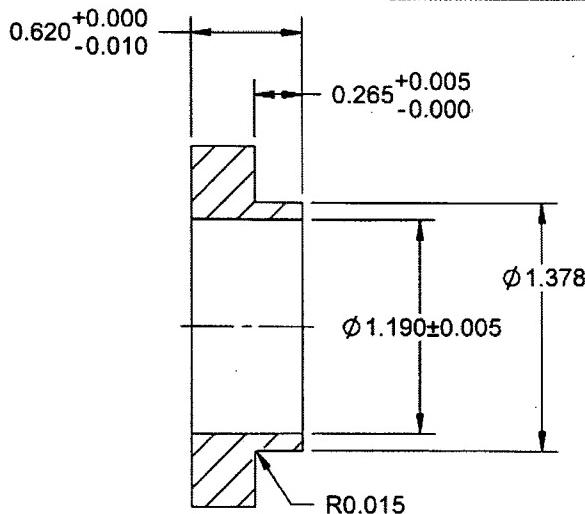
- 1) POSSIBLE SUPPLIER: McMaster-Carr, P/N 8353T74
 - 2) POSSIBLE SUPPLIER: GENERAL BEARING
 - 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH (4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
 - 4) POSSIBLE SUPPLIER: GENERAL BEARING
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 6) ALL DIMENSIONS ARE IN INCHES
- UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43627

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1	

**SECTION A-A****D3233-1 INSIDE WASHER****SECTION B-B****D3233-3 OUTSIDE WASHER**

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WORK ORDER

NO. 4360

NOTES:

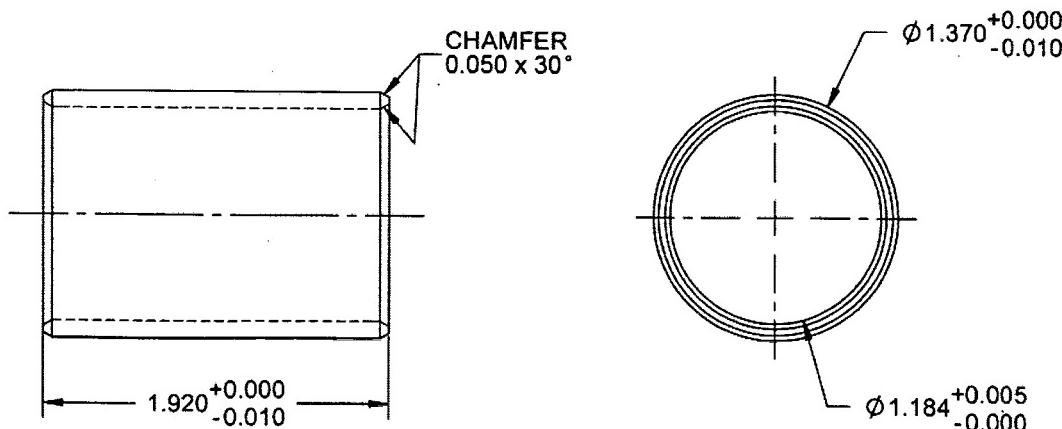
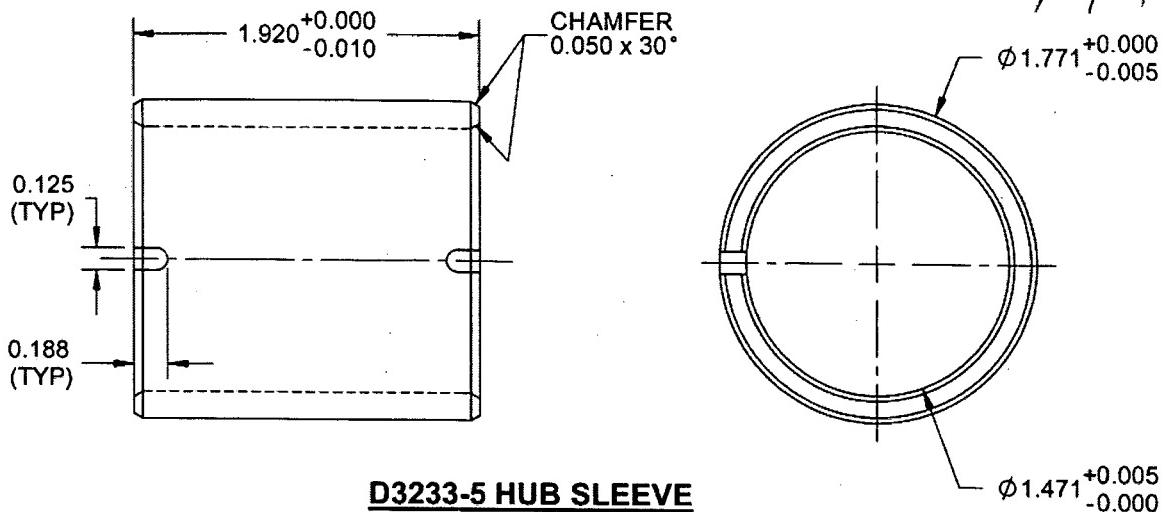
- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1	

RELEASED
[Signature]
05/05/04**D3233-7 SHAFT SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 UNCONTROLLED COPY
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS SUBJECT TO AMENDMENT
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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ENGINEERINGWITHOUT NOTICE
WORK ORDER
NO. *43620*

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